



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3254-041
Job Sheet 167933



Part No: D3254-041

Job Qty: 2 ea

Part Name: Side LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/8/17

Job Tracking No:

Due Date: 12/1/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/30/17	0.00	0.00	Start Up Waterjet1		SC
100	Waterjet	2 pcs		11/30/17	0.00	0.67	Waterjet1		SC
110	QC	2 pcs		11/30/17	0.00	0.00	QC2		SC
120	QC	2 pcs		11/30/17	0.00	0.00	QC8		AD 11.2.07
130	Brake NC	2 pcs		11/30/17	0.08	0.12	Brake NC 2		SB
140	QC	2 pcs		11/30/17	0.00	0.00	QC5		38
150	HandFinish	2 pcs		11/30/17	0.00	0.20	HandFinish1		BEB 12/12/11
151	QC	2 pcs		11/30/17	0.00	0.00	QC3		38
153	Small Fab	2 pcs		11/30/17	0.00	0.33	Small Fab		DAS
157	QC	2 pcs		11/30/17	0.00	0.00	QC5		38
170	Powdercoat	2 pcs		12/1/17	0.00	0.10	Powdercoat4		BR 12/12/12
180	QC	2 pcs		12/1/17	0.00	0.00	QC3		38
190	Packaging	2 pcs		12/1/17	0.00	0.00	Packaging3	1/247	Smf 3.89
200	QC21-SA	2 Ea		12/1/17	0.00	0.00	QC21		DAS 21 3.89

Part Op 100 - 1-Cut as per Dwg

Descriptions: 153 - Install D3248-1 as per dwg

170 - START TIME: 1:00 FINISH TIME: 1:30 O.V.T: 3:20

M 135418

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.063	13	309	0	0
153-Small Fab	D3248-1 5019863	4	0	0	0
	MS20470AD4-5 FA 136851-236	36	872	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				

Date: _____	Qty Effective: _____	MRB (QSI042) Approval
Description: _____ S016589 Side LH	Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

PART NO: D3254-041

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/03/17

Job No: 167933

Root Cause							
Environment ☐	Nc ☐						
Design ☐	Of ☐						
Doc/Data ☐	Of ☐						
Equip/Tooling ☐	SL ☐						
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/wave ☐	Inspection ☐	er Loss/Surge ☐	Positioned Wrong ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Program ☐	Outside Dimensions ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	n ☐	Over/Under tolerance ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	d ☐	Part Incorrect ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	ng Stock Pulled ☐	Part Lost/Missing ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Part Moved ☐		
Past Expiry Date ☐	Manufacturing Process ☐			Off-set ☐	Drawing ☐		
Misidentified ☐	Past Due ☐			Mislabeled ☐	Finish ☐		
				Fit/Function ☐	Misread ☐		
				Misaligned/off center ☐	Turning Sequence ☐		
		OTHER: _____					

DART AEROSPACE LTD		Work Order: 167933
Description: Side (Dual Battery Rack)		Part Number: D3254-1
Inspection Dwg: D3254	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.20	+/-0.030	5.207			VDE-02	
4.15	+/-0.030	4.159			Tape	
R0.19	+/-0.030	R0.19				
1.103	+/-0.010	1.103				
0.300	+/-0.010	0.302				
Ø0.098	+0.005/-0.000	Ø0.101				
1.300 Pitch	+/-0.005	1.301				
21.056	+/-0.010	21.058				
19.000	+/-0.010	19.000				
1.003	+/-0.010	1.000				
Ø1.125	+0.005/-0.000	Ø1.126				
5.403	+/-0.010	5.404				
Ø0.257	+0.005/-0.000	Ø0.260				
Ø1.500	+0.005/-0.000	Ø1.500				
2.750 Pitch	+/-0.005	2.751				
5.500	+/-0.010	5.506				
1.653	+/-0.010	1.655				
3.75	+/-0.030	3.762				
10.810	+/-0.010	10.812				
8.00	+/-0.030	8.014				
R0.50	+/-0.030	R0.50				
2.750 Pitch	+/-0.005	2.752				
4.125	+/-0.010	4.127				
1.375	+/-0.010	1.378				
Ø0.128	+0.005/-0.000	Ø0.132				
11.000	+/-0.010	11.002				
22.946	+/-0.010	22.949				
R0.30	+/-0.030	R0.30				
9.90	+/-0.030	9.917				
11.77	+/-0.030	11.782				
1.82	+/-0.030	1.831				
2.17	+/-0.030	2.181				
20.10	+/-0.030	20.11				
0.953	+/-0.010	0.957				
R0.125	+/-0.010	R0.125				
Grain along 20.10	N/A	OK				

Measured by: SC	Audited by: DD	Prototype Approval:	N/A
Date: 17/12/01	Date: 17.12.07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue P/O D205-579-015	KJ/JLM	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								